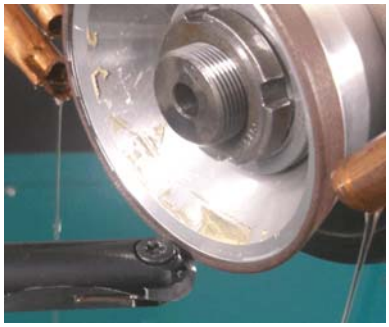
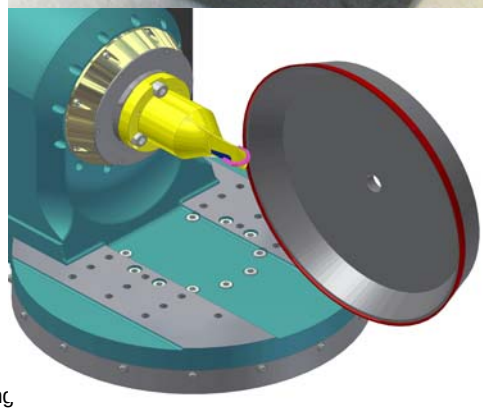
Ballnose Insert Ø16 Z2

A08-500

The special gulltet design requires the usage of a small wheel as shown in the picture to the right. Gashing and gullet are 2 different operations which intersect in the middle of the radiusform. The Radiusgashing causes formdistortions that can be compensated by setting discrete correctionpoints along the radius. An automatic hydraulic clamping device is available for the production of large batches of ballnoseinserts with automatic loader.





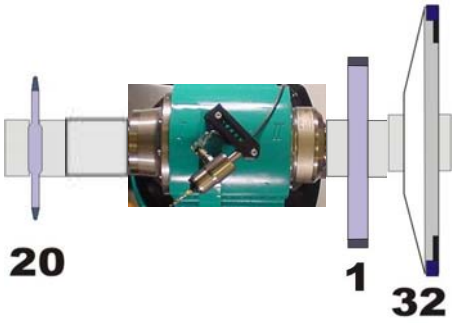
1. Cycletime for Production

Tool specifications Diameter 16 mm, Z 2, Helix angle 25º Material CARBIDE				
Operations	Gullet	Gashing	O.D.2	O.D.1
Feed [mm/Min]	160	80	200	280
Power [kW]	4	2	1	1
Cutting feed [m/s]	18	32	24	24
Used wheels	20	1	32	32
Grinding time [s]	39	35	99	66
Total cycle time	3 Min 58			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

20	14EE1 Ø50-
1	1A1 Ø200
32	12C9 Ø250



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3

responsible engineer: OP, 19.8.08

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